

514 5. (Amended) A method as claimed in claim 1, wherein said other roll is held against lateral bodily movement, said one roll is mounted on a pair of moveable roll carriers which allow said one roll to move bodily laterally of the other roll and said one roll is continuously biased laterally toward the other roll by application of biasing forces to the moveable rolls carriers.

6. (Amended) A method as claimed in claim 1, wherein the initial gap between the rolls is set by positioning of a stop to limit bodily movement of said one roll toward the other.

Please add new claims 8-20 as follows:

8. (NEW) A method as claimed in claim 3, wherein the radial negative crown for each roll is in the range 0.1 to 1.5mm.

9. (NEW) A method as claimed in claim 2, wherein said other roll is held against lateral bodily movement, said one roll is mounted on a pair of moveable roll carriers which allow said one roll to move bodily laterally of the other roll and said one roll is continuously biased laterally toward the other roll by application of biasing forces to the moveable rolls carriers.

a5 10. (NEW) A method as claimed in claim 3, wherein said other roll is held against lateral bodily movement, said one roll is mounted on a pair of moveable roll carriers which allow said one roll to move bodily laterally of the other roll and said one roll is continuously biased laterally toward the other roll by application of biasing forces to the moveable rolls carriers.

11. (NEW) A method as claimed in claim 4, wherein said other roll is held against lateral bodily movement, said one roll is mounted on a pair of moveable roll carriers which allow said one roll to move bodily laterally of the other roll and said one roll is continuously biased laterally toward the other roll by application of biasing forces to the moveable rolls carriers.

12. (NEW) A method as claimed in claim 8, wherein said other roll is held against lateral bodily movement, said one roll is mounted on a pair of moveable roll carriers which allow said one roll to move bodily laterally of the other roll and said one roll is

continuously biased laterally toward the other roll by application of biasing forces to the moveable rolls carriers.

13. (NEW) A method as claimed in claim 2, wherein the initial gap between the rolls is set by positioning of a stop to limit bodily movement of said one roll toward the other.

14. (NEW) A method as claimed in claim 3, wherein the initial gap between the rolls is set by positioning of a stop to limit bodily movement of said one roll toward the other.

15. (NEW) A method as claimed in claim 4, wherein the initial gap between the rolls is set by positioning of a stop to limit bodily movement of said one roll toward the other.

16. (NEW) A method as claimed in claim 8, wherein the initial gap between the rolls is set by positioning of a stop to limit bodily movement of said one roll toward the other.

17. (NEW) A method as claimed in claim 13, wherein the stop is a stop which is set so as to be engaged by one or both of the moveable roll carriers.

18. (NEW) A method as claimed in claim 14, wherein the stop is a stop which is set so as to be engaged by one or both of the moveable roll carriers.

19. (NEW) A method as claimed in claim 15, wherein the stop is a stop which is set so as to be engaged by one or both of the moveable roll carriers.

20. (NEW) A method as claimed in claim 16, wherein the stop is a stop which is set so as to be engaged by one or both of the moveable roll carriers.

21. (NEW) A method as claimed in claim 1, wherein said one roll is continuously biased laterally toward the other roll by a spring mechanism.

22. (NEW) A method as claimed in claim 1, wherein said one roll is continuously biased laterally toward the other roll by a hydraulic mechanism.

23. (NEW) A method as claimed in claim 1, wherein said one roll is continuously biased laterally toward the other roll by a servo mechanism.